

Date: Tuesday, 27/01/2009 11:11:32 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FRAME WELDMENT
<b>Job Number</b> : 45274	
<b>Estimate Number</b> : 11202	
<b>P.O. Number</b> :	<b>Part Number</b> : D3330041
<b>This Issue</b> : 27/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3330 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 45225	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/02/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JD 09.01.27</u>	
<b>Comment</b> : Est. A05.01.13 New Issue KJ/JLM	
est B 07.05.14 revC dwg ec	
Est C 07.12.19 Rev D ecn1085 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33301	Panel
-----	--------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-1 Panel

B44238 → 1

B43333 → 1

Cpl 09.03.25

2.0	D33302	Panel
-----	--------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-2 Panel

B44239

Cpl 09.03.25

3.0	D33303	Panel
-----	--------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-3 Panel

B44308

Cpl 09.03.25

4.0	D33305	Panel
-----	--------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rail

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:32 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 45274

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3330-5 Panel

*B45077*

*Cpl 09-03-25*

5.0 D33307

Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-7 Panel

*B44241 → 1 B45334 → 1*

*Cpl 09-03-25*

6.0 D33309

Top Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Top Plate

Pick:

Qty Part Number Description Batch

1 D3330-9 Panel

*B45079*

*Cpl 09-03-25*

7.0 D333011

Long Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Long Pin Bracket

Pick:

Qty Part Number Description Batch

1 D3330-11 Long Pin Bracket

*B45176*

*Cpl 09-03-25*

8.0 D333013

Short Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Short Pin Bracket

Pick:

Qty Part Number Description Batch

1 D3330-13 Short Pin Bracket

*B45177*

*Cpl 09-03-25*

9.0 D333015

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D3330-15 Handle

*B37080*

*Cpl 09-03-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:32 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 45274

Part Number: D3330041

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 D333017 Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle Socket

Pick:

Qty Part Number Description Batch  
1 D3330-17 Handle Socket ~~B3330-17~~ B44204

Cpl 09-03-25

11.0 D333019 Handle Rim



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle Rim

Pick:

Qty Part Number Description Batch  
1 D3330-19 Handle Rim B35485

Cpl 09-03-25

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1

Identify as D3330-041

Cpl 09-03-30

13.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09-03-30 (2)

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/30 (2)

15.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 12:45pm

OVEN TEMPERATURE: 320°C

FINISH TIME: 1:15pm

M 09-04-16 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 45274

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

OK 09-04-16

17.0

PACKAGING 1

PACKAGING RESOURCE #1



(2)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Carl

9/4/17

SP

18.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/22 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C209104117

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

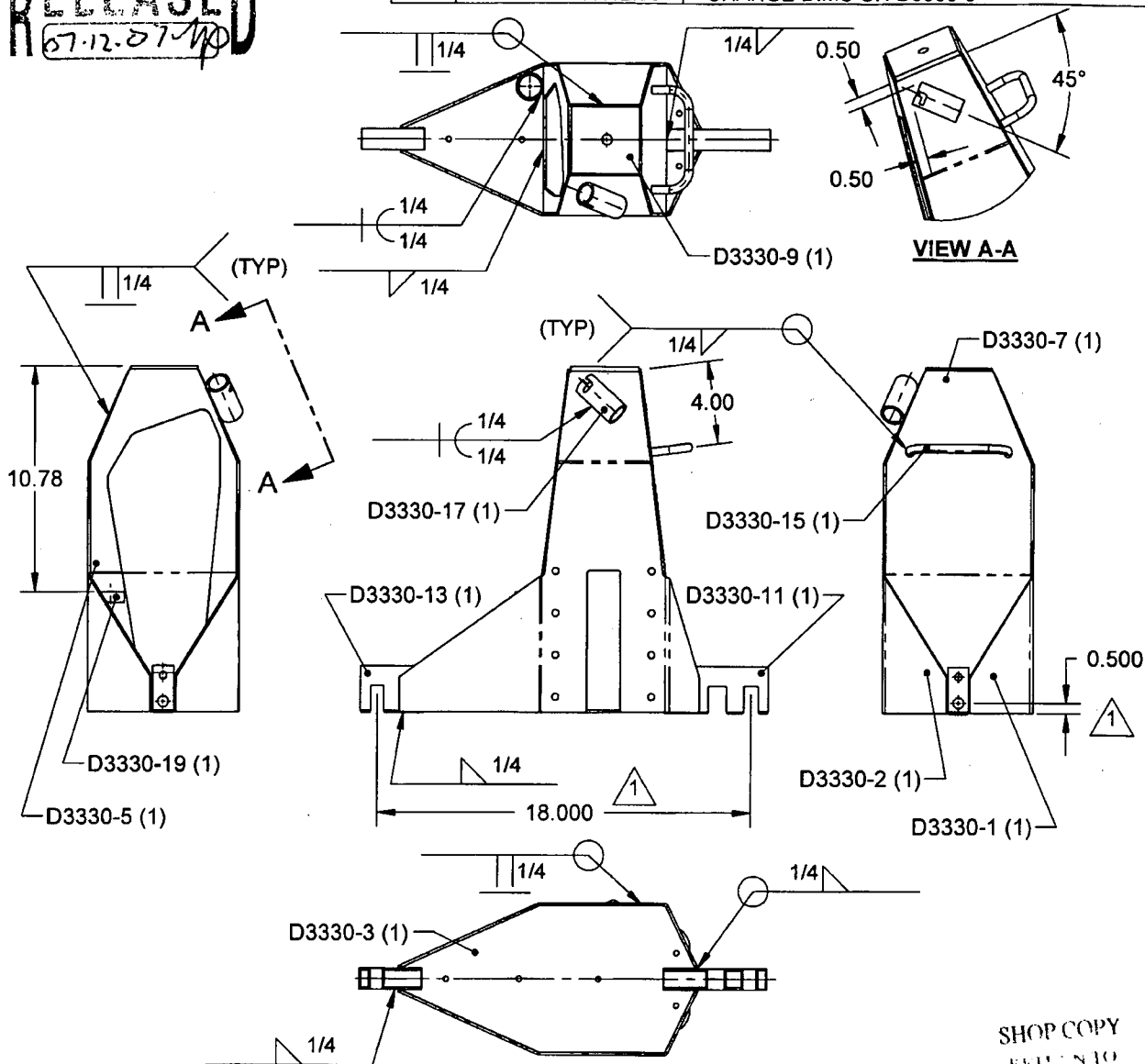
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>TS</i>	APPROVED <i>W</i>	DRAWING NO. <b>D3330</b>	REV. D SHEET 1 OF 9
DATE <b>07.12.06</b>	TITLE <b>FRAME WELDMENT</b>		SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/-2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

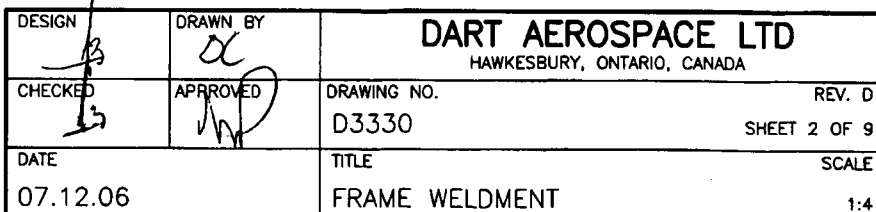
**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

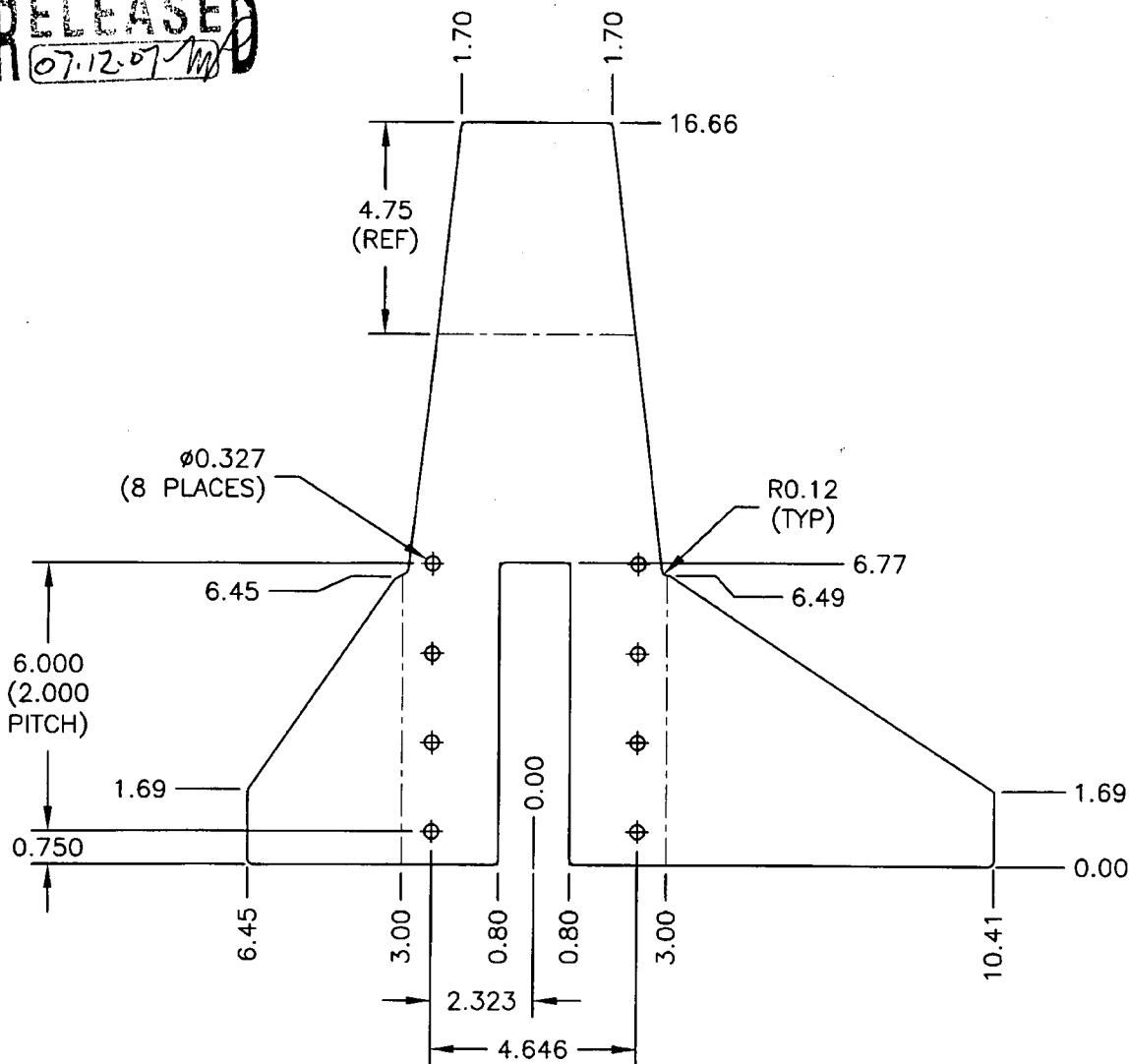
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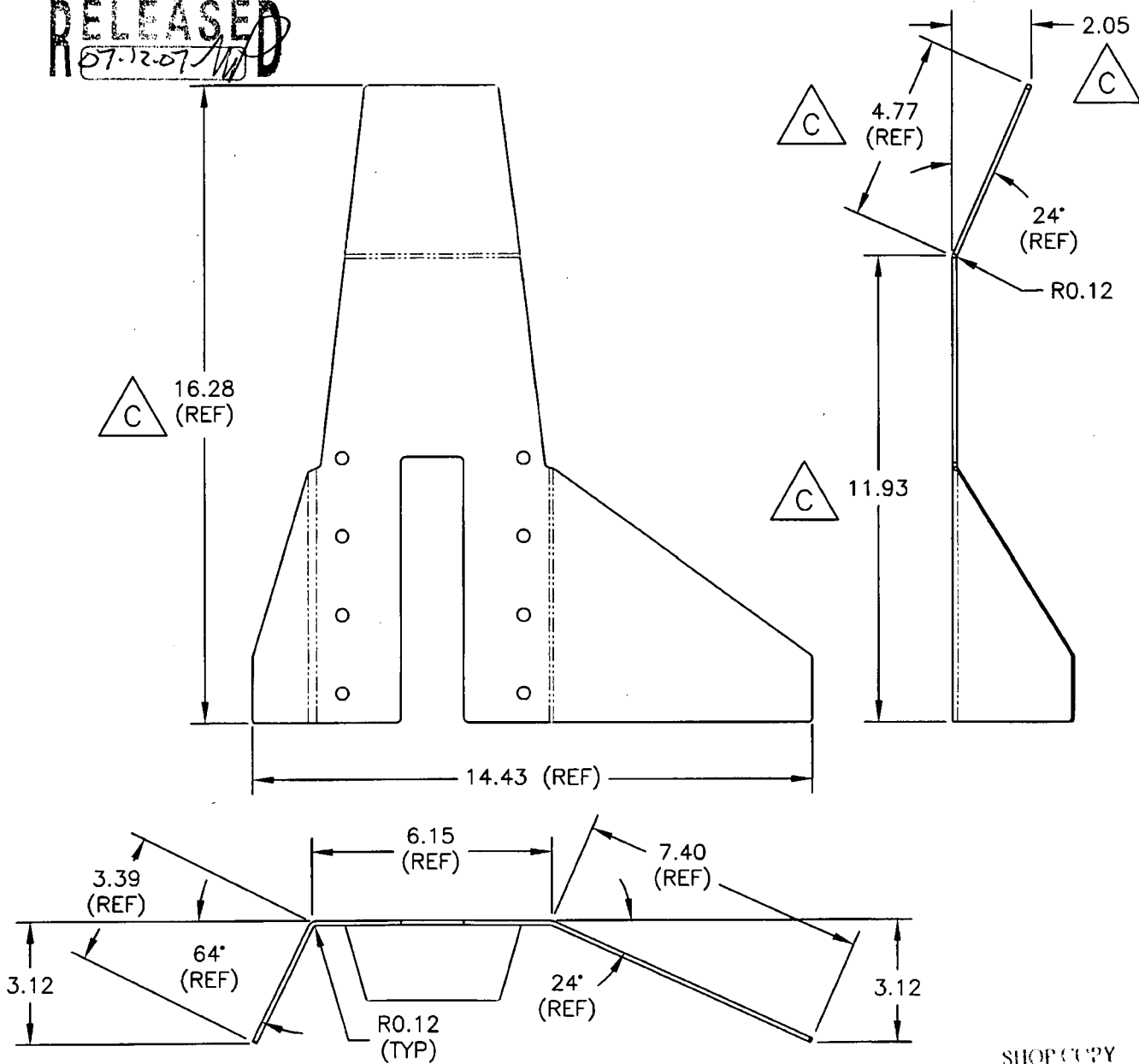
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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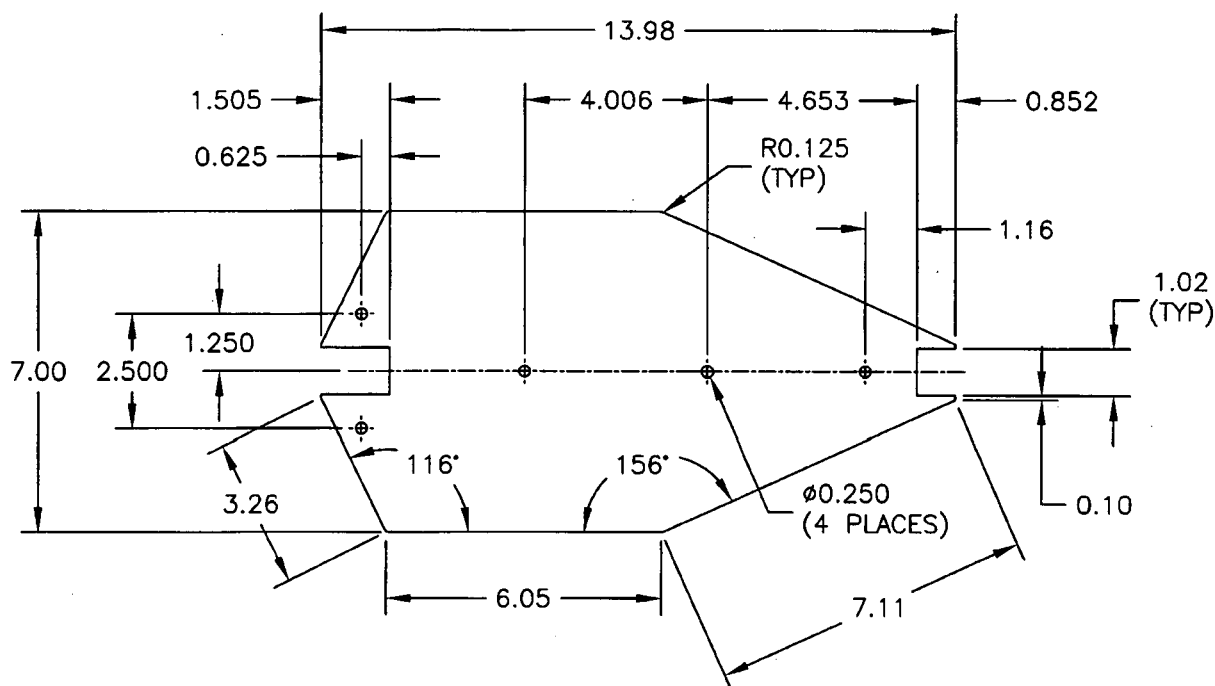


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BEND D3330-2 (OPPOSITE)

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DATE		TITLE	SCALE
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D3330-3 PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)  
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W. 140011 N° 3, 11, 12

**VOLUME 1**

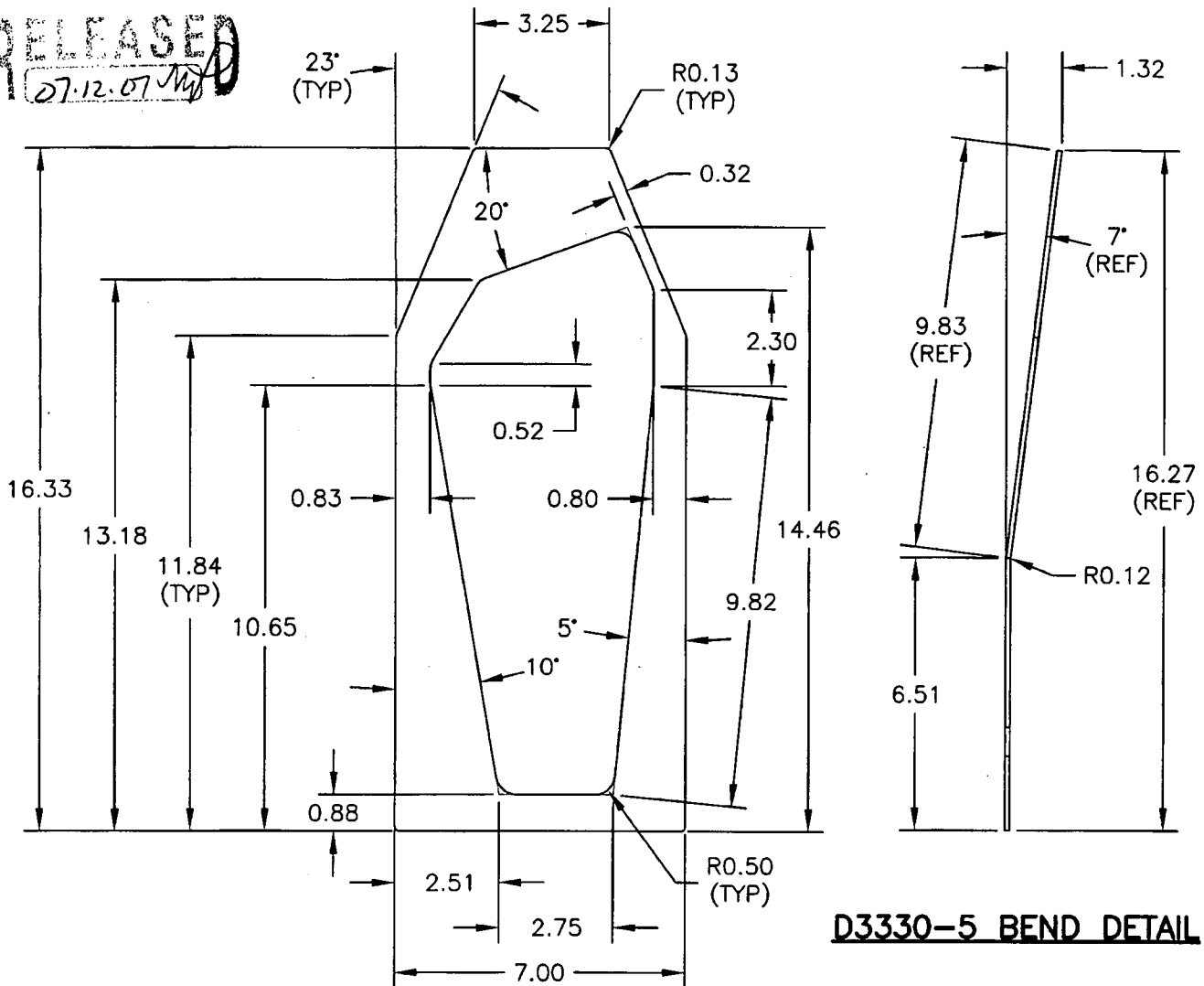
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DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:4

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27.12.07**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125" THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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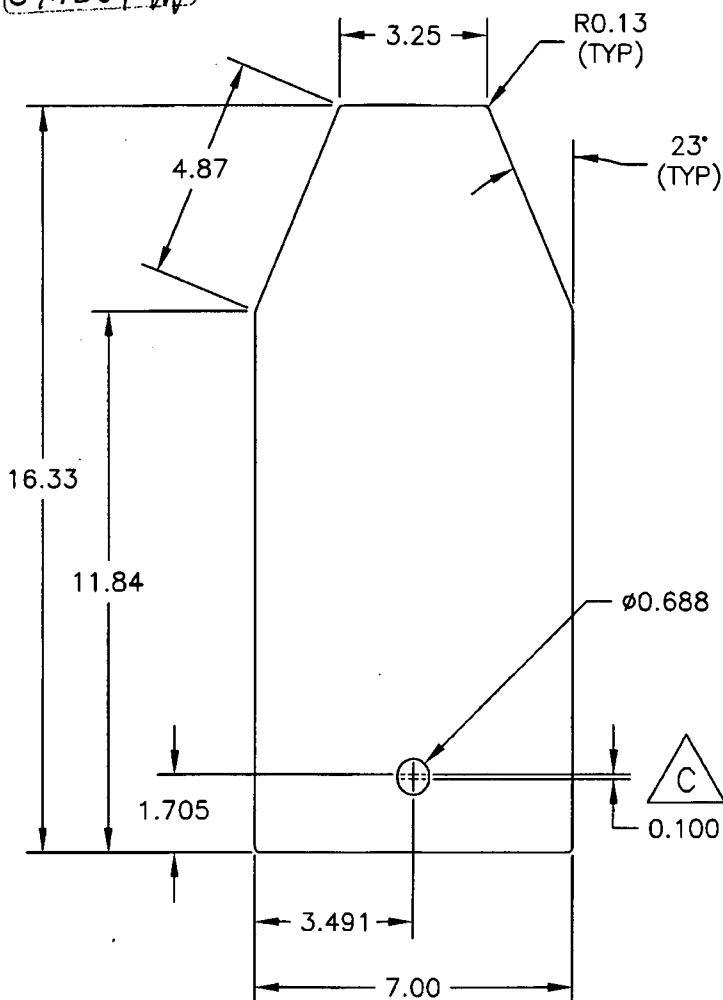
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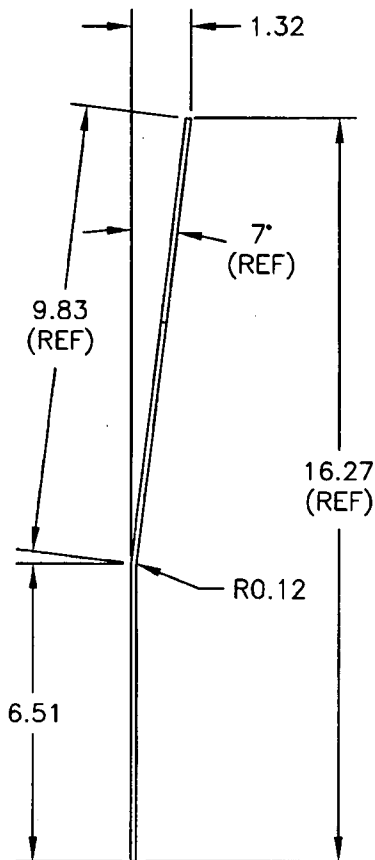


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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

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**FLAT PATTERN**



**D3330-7 BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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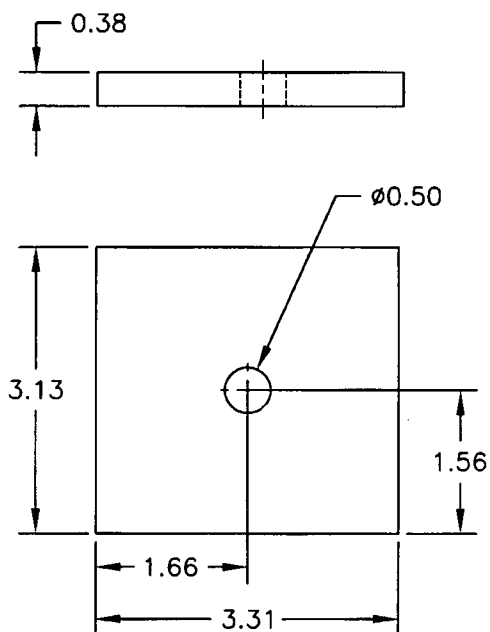
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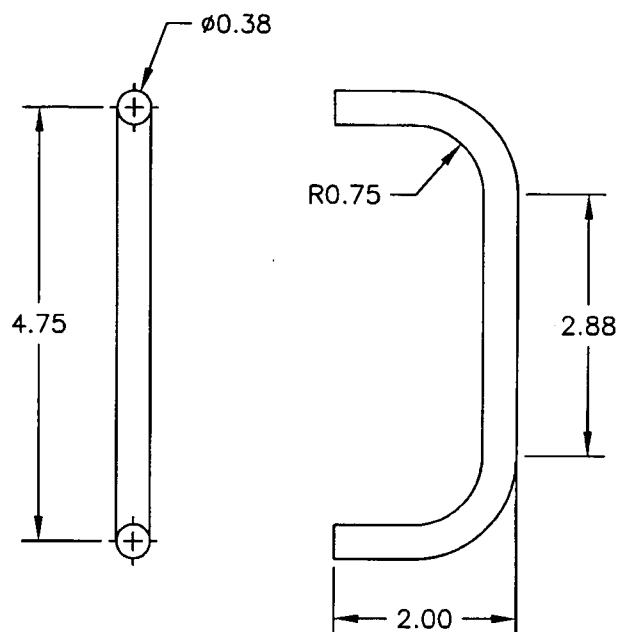


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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

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1 D3330-9 TOP PLATE



2 D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL  
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097  
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

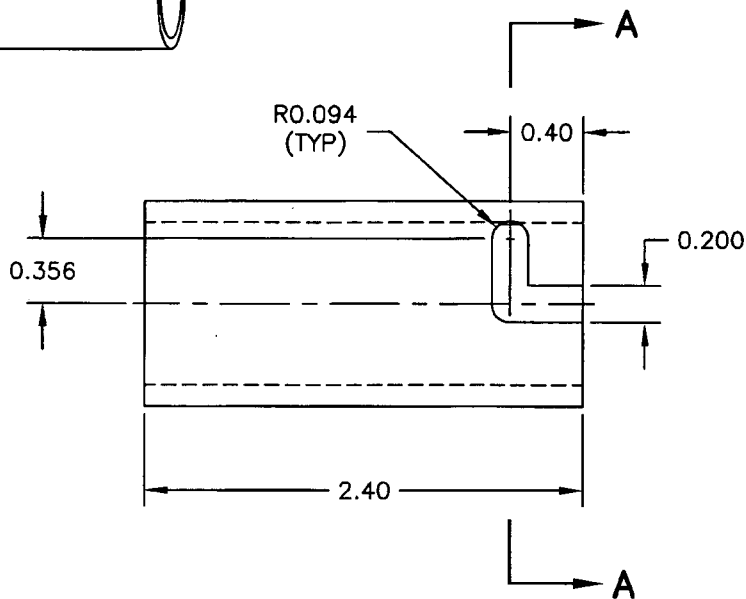
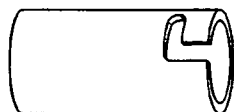
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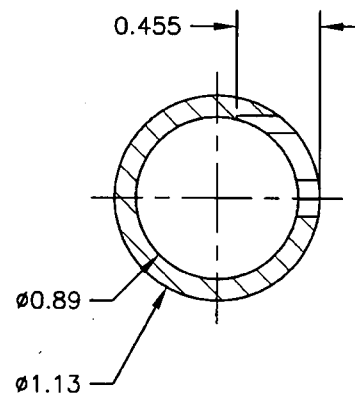
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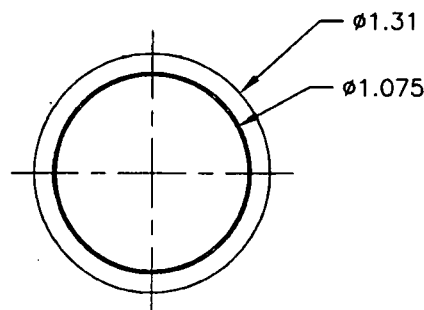
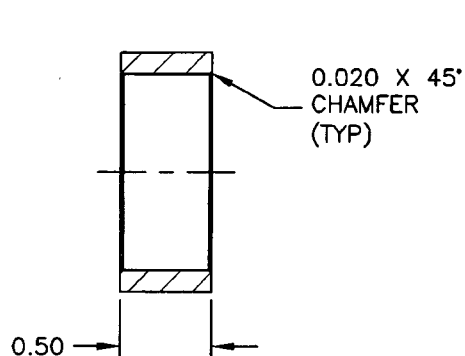


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**SECTION A-A**

**D3330-17 HANDLE SOCKET**



**D3330-19 HANDLE RIM**

**NOTES:**

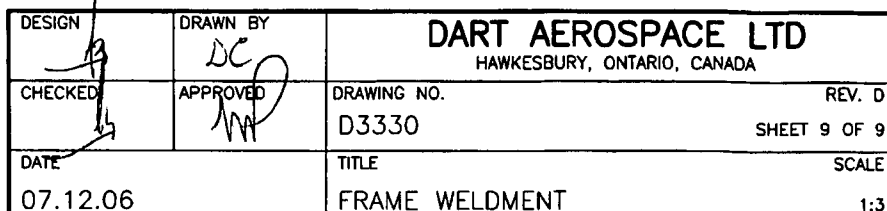
- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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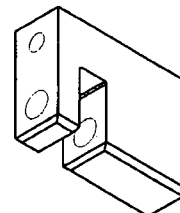
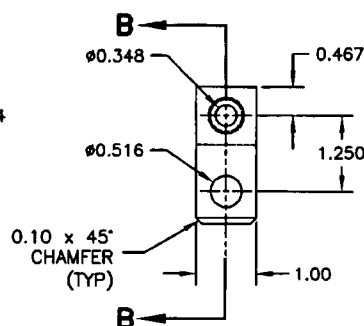
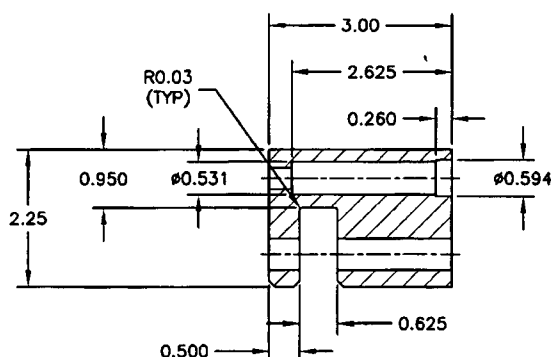
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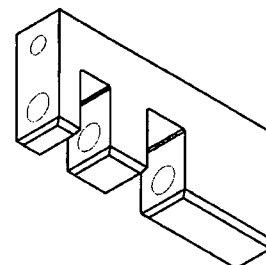
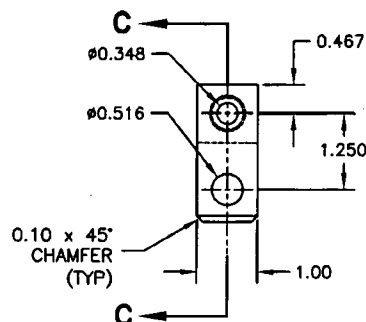
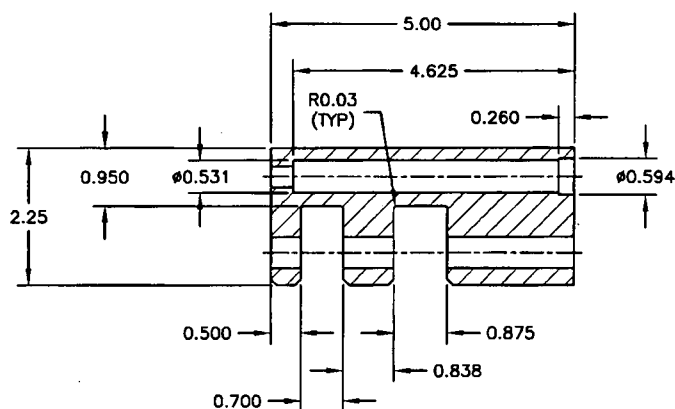




07.12.07 *[Signature]*



**D3330-13 SHORT PIN BRACKET**



**D3330-11 LONG PIN BRACKET**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00  
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOOT COPY  
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